

AMENDMENTS TO THE CLAIMS:

This listing of claims will replace all prior versions, and listings, of claims in the application:

LISTING OF CLAIMS:

Claims 1 – 15 (canceled)

16. (currently amended) A method for producing a synthetic stone rail article by centrifugal molding in the form of a balustrade product containing holes and including a rotatable centrifugal mold having an upper half and a lower half together defining [[a]] an inner cylindrical surface defining a cavity shaped to form the balustrade product and with the cavity being adapted to receive a slurry of synthetic stone material composition, the improvement comprising the steps of:

assembling an insert member by extending a plurality of pipes through a plurality of openings in a plurality of supports and spacing the supports at longitudinally spaced intervals relative to one another along the length of the plurality of pipes, circumferentially spacing a plurality of tabs about an outer diameter of each support radially, and sizing the plurality of tabs for engaging the inner cylindrical surface of the mold consequently positioning the pipes in parallel relation to one another and in parallel relation to a center axis on the mold;

setting said insert member into the lower half while the mold is in an open state with the plurality of supports being arranged perpendicular to a longitudinal axis of the mold and the plurality of pipes being arranged parallel with the longitudinal axis of the mold;

pouring a predetermined amount of the slurry of synthetic material composition into said lower half of said mold and closing the mold halves;

tightening the mold halves in a closed state and thereby pressing the tabs on the insert member against the cylindrical inner surface of the mold and also thereby positioning the pipes centrally to the mold halves;

rotating [[,]] the elongated tubular mold on its generally longitudinal axis causing said slurry of synthetic material composition to acquire the form of the inner cylindrical surface within said mold in response to the rotation of the mold and resultant centrifugal force, the predetermined amount of slurry of synthetic material composition becomes distributed in said cavity and coacting with the cylindrical inner surface to form a balustrade product with the insert member integral with the balustrade product;

solidifying said slurry of synthetic material composition in said mold such as to form a blank hollow cylinder within the balustrade product;

separating the upper and the lower halves of the mold; and
removing the balustrade product.

17. (currently amended) The method in claim 16, wherein the mold is made from [[a]] an extruded aluminum, the plurality of supports are made from the slurry material composition and the plurality of pipes are made from a PVC material.

18. (currently amended) A method for centrifugal molding a balustrade product

comprising the steps of:

providing a mold for producing the balustrade product, the mold having an inside mold surface defining a mold cavity, the mold having an upper and lower half;

providing a plurality of insert members to define a plurality of open spaces in the interior of the balustrade product;

placing said insert ~~member~~ members into the lower half while the mold is in an open state;

pouring a slurry material composition into the open lower half;

tightening the upper and lower half in a closed state;

rotating the mold generally about a longitudinal axis;

allowing the slurry material composition to solidify [[;]] thus embedding the insert members in the slurry material to form a balustrade product, the insert members being integral with balustrade product; and

removing the balustrade product from the mold.

19. (currently amended) The method of claim 18, wherein the mold being made of

[[a]] an extruded aluminum, the centrifugal mold having an upper half and a

lower half together when in a closed state defining [[a]] an inner cylindrical

surface defining a cavity shaped to form the balustrade product and with the

cavity being adapted to receive a slurry of synthetic stone material composition.

20. (original) The method of claim 18, further comprising the step of grinding the

outer surface of the balustrade product after removing the balustrade product

from the mold to remove any surface imperfections resulting from the use of the

mold.

21. (currently amended) A method of manufacturing a balustrade product

comprising the steps of:

providing a mold having an inner cylindrical surface defining a cavity,

extending the plurality of hollow pipes within the mold to be integrated

into the balustrade product, the hollow pipes spanning substantially the entire

length of the cavity,

securing the hollow pipes within the cavity of the mold in a preset position

that is parallel to its longitudinal axis and in close proximity to the inner

cylindrical surface,

pouring a predetermined amount of casting material into the mold,

rotating said mold until the casting material has set, the set casting material thus embedding the hollow pipes in the casting material to form a balustrade product, the hollow pipes being integral with balustrade product to form the balustrade product, and

removing the balustrade product from the mold.

22. (original) The method of claim 21, wherein the step of securing the hollow pipes within the cavity further comprising the steps of providing a plurality of supports within the mold having a plurality of openings, and extending the plurality of hollow pipes through the plurality of openings, wherein the diameter of each opening is slightly larger than the diameter of the hollow pipe passing therethrough.

23. (original) The method of claim 22 further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby assisting in holding the hollow pipes in a suspended preset position within the mold.

24. (original) The method of claim 23 further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby embedding the tabs in the balustrade product after the casting material has set.

25. (original) The method of claim 21 further comprising the step of grinding the outer surface of the balustrade product after removing the balustrade product from the mold to provide a smooth outer surface.

26. (original) The method of claim 21, wherein the casting material comprises a slurry of synthetic stone material.

27. (currently amended) A method of manufacturing a balustrade product comprising the steps of:

providing a mold having a first half and a second half, the first and second mold halves defining an inner cylindrical surface,
stabilizing a plurality of hollow pipes within the mold parallel to the longitudinal axis of the mold and in close proximity to the inner cylindrical surface,

pouring a predetermined amount of casting material into the second half of the mold,

securing the first and second mold halves together,
rotating said mold until the casting material has set, the set casting material thus embedding the hollow pipes in the casting material to form a balustrade product, the hollow pipes being integral with balustrade product to form the balustrade product, and

removing the balustrade product from the mold.

28. (original) The method of claim 27, wherein the step of stabilizing comprises the steps of extending the plurality of hollow pipes through a plurality of openings in a plurality of supports, and placing same in the second mold half.
29. (original) The method of claim 28 further comprising the step of spacing the plurality of supports longitudinally along the length of the plurality of hollow pipes at predetermined intervals.
30. (original) The method of claim 29 further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby assisting in holding the hollow pipes in a suspended preset position within the mold.
31. (original) The method of claim 30 further comprising the step of engaging a plurality of tabs radially outwardly extending from the supports against the inner cylindrical surface of the mold thereby embedding the tabs in the balustrade product after the casting material has set.